

**Work Order ID 54894**

Page 1

January 5, 2010 8:35:56 AM

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: 10-1-05 Tooling:

Run Start



QC:

Date: SPC (Y/N):

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
-------------	-----------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

D2580

Rev D

0.00

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

*PL 10-1-26*

110



BENDING MACHINE - SKIDTUBES

0.00

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*(X)*
*(Q)*
*MBS 10-01-07*
*894*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Skidtubes

Memo

0.00

- AWM 10-01-11

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130



QC5- Inspect part completeness to step on W/O

0.00

(i)

RE 10-01-11

QC

Memo

0.00

Quality Control

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SPC (Y/N):

Date:

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NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004  
A/R 111 Aluminum Rod

m112860 80 10/01/12

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580. QSI  
004.For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R 111 Aluminum Rod

m112860 80 10/01/12

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.  
Deburr holes.

6-Drill pilot holes for af cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Towring using DT8091, open to .640"and Deburr

JWY  
10-1-13

W/O:		WORK ORDER CHANGES							
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QtyReject  
NumberInsp.  
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00

→ S101013

(OK)

QC

Memo

0.00

160

QC5- Inspect part completeness to step on W/O

0.00

→ S101013

(OK) +

QC

Memo

0.00

170

Pressure Wash per QSI005 4.3

0.00

MM 10-01-18

(X) - 9

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
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NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113\$88

0.00

=) M 10-01-19

(X) - Ø

Powder Coating

Memo

START TIME: 16:15AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 10:45AM

190



QC3- Inspect Part Finish

0.00

BK 10-01-19

Ø Ø

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 18/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInsp.  
Stamp

200



HandFinish

Hand Finishing

Memo 0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R 112900 Sikaflex-291 112900 000

Sikaflex expire date: 10/08.

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R 112900 Sikaflex-291 112900 000

Sikaflex expire date: 10/08.

5-Wing Walk as per Dwg D2580 and QSI 005 4.4  
Batch: 112900.

JL 10-01-19 (1)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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January 5, 2010 8:35:57 AM

Item ID: D205-634-041

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Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ 5/10/10/20

(OK)

J

220



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: F

10/01/2010 (OK)

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/2010 (OK)

MF

10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 1

January 5, 2010 8:41:10 AM

Work Order ID: 54894

Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch
D2580-1		Manufactured

Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
	No		110	Each	8.0000	1.0000			

205 Skidtube bent detail



Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

LG

4

54120

1

54279

1

54541

2

res 10-01-07

Main Warehouse

ST

4

54500

2

54647

2

D2576-3

Manufactured

No

140

Each

151.0000 1.0000



Step (machining detail)



Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST

151

43504

3

46661

101

52215

47

1

AB 10/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Picklist Print**

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January 5, 2010 8:41:11 AM

Work Order ID: 54894

Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579		Manufactured	No			140	Each	381.0000	20.0000			

Crossbolt Spacer

WarehouseLocation

## Main Warehouse

LG	259	
51525	4	
53780	3	
54543	38	
54642	214	

## Main Warehouse

ST	122	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	

20

SC 10/01/12

January 5, 2010 8:41:11 AM

Shop Packet Print

Page 2

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855		Manufactured	No			200	Each	160.0000	1.0000			

Cap

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

FP6	160	
50513	1	
50770	1	
51539	42	
53791 ✓	116	

AN3-5A



Purchased

No

200      Each      1,975.000 2.0000



1 Bl 10-01-19.

Bolt

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

ST	1975	
100188 ✓	188	
105057 ✓	1787	

2 Bl 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 1.00

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Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased		No		200	Each	4,915.000	2.0000			

Washer

## Warehouse

### Location

#### Main Warehouse

ST	4915
101291	16
104885	25
105793	236
109632	174
110985 ✓	4464

## Loc Qty

## Loc Code

2. BK 10-01-19.

ALS7-1032-130



Purchased

No

200 Each 1,530.000 50.0000



Insert

## Warehouse

### Location

#### Main Warehouse

ST	1530
105855	16
108606	52
111529	188
111779 ✓	313
112772	11
113238	950

## Loc Qty

## Loc Code

50 BK 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			200	Each	1,195.000	50.0000			

BOLT

## Warehouse Loc Qty Loc Code

### Location

#### Main Warehouse

ST	1195	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226	586	
113359	14	
113422	500	

50. BK 10-01-19.

AN960C10L

Purchased

No

200 Each 416.0000 50.0000



washer

NIAS1149C0332R.

## Warehouse Loc Qty Loc Code

### Location

#### OFFSHORE

FG	100	
103585	100	

50 BK 10-01-19.

#### Main Warehouse

ST	316	
112116	156	
112612	160	

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Shop Packet Print

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**Comments:**

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Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-13		Manufactured	No			200	Each	94.0000	1.0000			

Gasket

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

FP	92
51606	9
53461	83

*1 Bl 10-01-19.*

## Main Warehouse

ST	2
45717	1
50265	1

*\_\_\_\_\_*

D3566-5

Manufactured No

200 Each 15.0000 1.0000



Gasket

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

FP	11
53804	11

*1 Bl 10-01-19.*

## Main Warehouse

ST	4
36113	1
46186	1
47318	1
51260	1

W/O:		WORK ORDER CHANGES					
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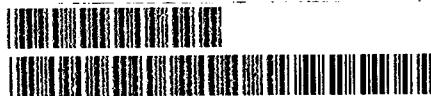
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Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 18/01/2010

## Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3566-1

Manufactured

No

200

Each

27.0000

2.0000

Gasket



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

## Main Warehouse

FP

22

52512 ✓

3

54480 ✓

19

2 BK 10-01-19.

## Main Warehouse

ST

5

46349

1

51218

1

51259

3

D3564-11

Manufactured

No

200

Each

16.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

## Main Warehouse

FP19

14

52125 ✓

14

1 BK 10-01-19.

## Main Warehouse

ST

2

45823

1

50112

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 8

January 5, 2010 8:41:11 AM

Work Order ID: 54894



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13		Manufactured	No			200	Each	34.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

## Main Warehouse

FP17

22

51611✓

22

1 BK 10-01-19.

## Main Warehouse

ST

12

45409

2

46495

10

D3564-9

Manufactured No

200

Each

13.0000

1.0000

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

## Main Warehouse

FP19

11

53806✓

11

1 BK 10-01-19.

## Main Warehouse

ST

2

44659

1

45825

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 9

January 5, 2010 8:41:11 AM

Work Order ID: 54894



Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 18/01/2010

## Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5		Manufactured	No			200	Each	14.0000	1.0000			

Wearshoe

WarehouseLocation

## OFFSHORE

FG 2

34806 2

## Main Warehouse

FP19 10

51925 1

53805 9

## Main Warehouse

ST 2

45824 1

47433 1

D2594-3

Manufactured No

200

Each

362.0000 16.0000



O-Ring, 205 Skidtube

WarehouseLocation

## Main Warehouse

FP 27

51613 27

## Main Warehouse

ST 335

52562 335

*16 bl 10-01-19.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 10

January 5, 2010 8:41:11 AM

Work Order ID: 54894



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 18/01/2010

## Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1		Manufactured	No			200	Each	250.0000	16.0000			

Plug, 205 Skidtube



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

## Main Warehouse

FP	122	
54008	17	
54643 ✓	105	

16. Bk 10-00-102.

## Main Warehouse

ST	128	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>#</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07.06.28

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 54894

BY 10-1-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



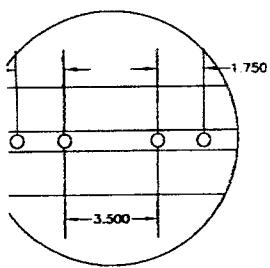
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

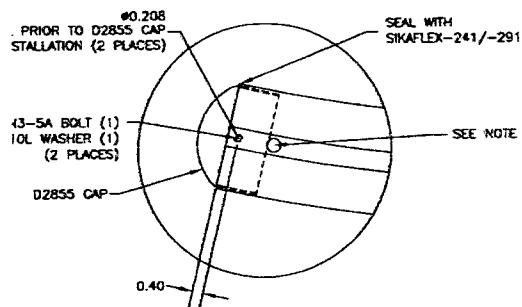
NOTE: Date & initial all entries

DETAIL ?  
SCALE 5:24

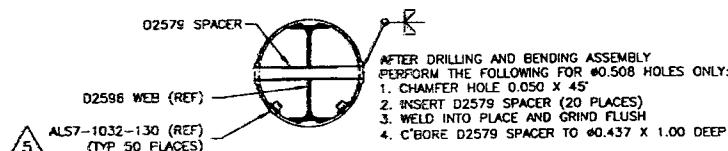


RELEASED  
07-26-2014

DETAIL G  
SCALE 5:24



**SECTION H-H**  
**SCALE 5:24**

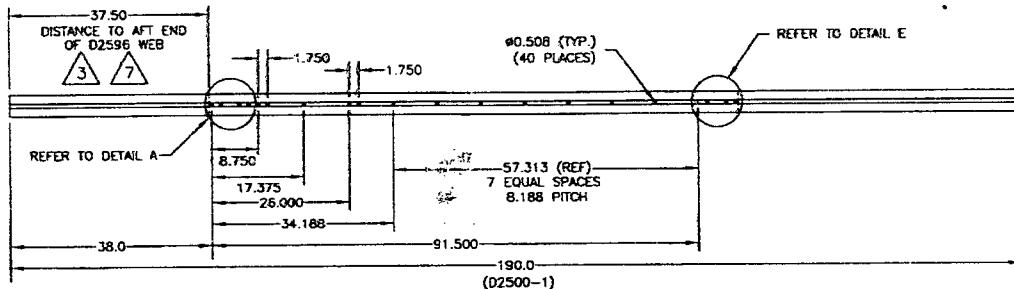


-045 NOTES

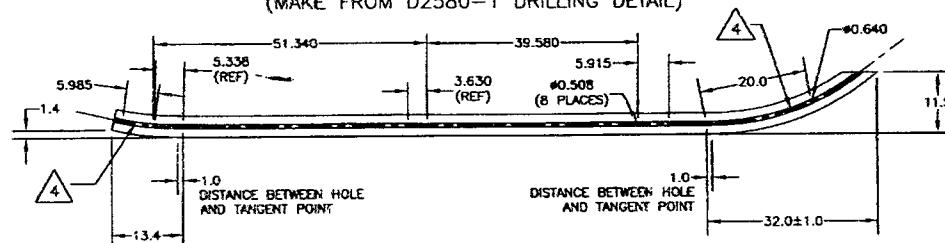
INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE  
WITH THE SPACER AT THIS LOCATION

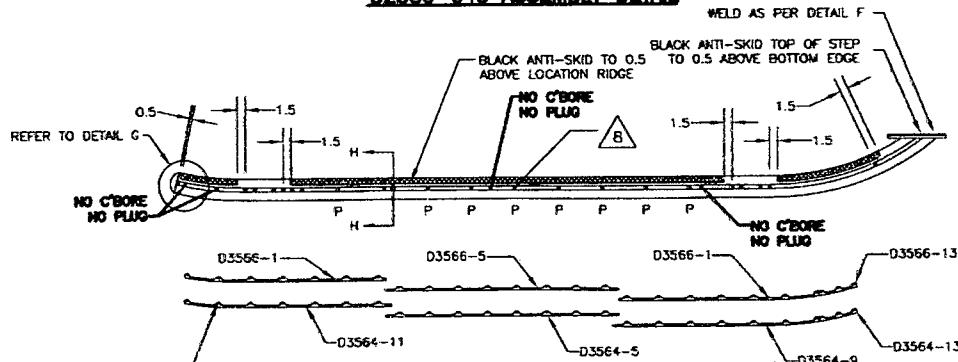
D2580-1 DRILLING DETAIL



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



**D2580-045 ASSEMBLY DETAIL**



w/c 54894

AN3C4A BOLT (1)  
AN950C10L WASHER (1)  
(50 PLACES)

CONTINENTAL 1200 SX PART AEROSPACE LTD

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AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	<b>DART</b>	DART AEROSPACE LTD. KAWARSHIERRY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 221

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 542020  
Part number: D205 634 041  
Description: 205 skid tube  
Welding Process: Tig[] Mig[]  
Base material: Aluminium  
Current: AC[] DC[]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[] fail[]  
Penetration: pass[] fail[]

**UNACCEPTABLE**

Cracks: pass[] fail[]  
Undercut: pass[] fail[]  
Pin holes: pass[] fail[]  
Overlap (cold lap) pass[] fail[]  
Porosity (surface): pass[] fail[]  
Coloration: pass[] fail[]

Qualifier Barclay Elliott Date of Test Coupon 09.12.17

Welder Barclay Elliott Date of Test Coupon 09.12.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld